

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006939**Date Inspected:** 29-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 6-Tower Assembly

This QA Inspector randomly observed the following work in progress:

**SMAW Process:**

Welding of weld joints# B/B-4 located on PCMK ESD1 DPSA4-11. Welder is identified as 069493. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

Welding of weld joints# B/B-5 located on PCMK ESD1 DPSA4-11. Welder is identified as 066459. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

Welding of weld joints# B/B-8 located on PCMK WSD1 DPSA4-5. Welder is identified as 066481&037779. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3312-TC-P5.

**SAW Process:**

Welding of weld joints# 1A located on PCMK NSD1 SA658-77M-14. Welder is identified as 054458. ZPMC QC

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U5-S-1.

Bay # 7-OBG Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld joints# 3&4 located on PCMK DP 203-016. Welder is identified as 054459. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints# 11&12 located on PCMK DP 203-016. Welder is identified as 062447. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Welding of weld joints# 7&8 located on PCMK DP 203-016. Welder is identified as 051246. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132-3.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

### Summary of Conversations:

FOLLOWING DIAPHRAGMS WERE OFFERED FOR Magnetic Particle Testing (MT) AND GREEN TAG:

1. ESD1 DPSA4-10 B/B-20,21,22,23,24,25
2. ESD1 DPSA4-4 B/B-8,9,10,11,14,15,18,19,1,2,26,27 A/B-3,4,5,6,7,8
3. ESD1 DPSA4-5 B/B-1,2,4,5,8,9,12,13,16,17,26,27 A/B-3,4,5,6,7,8

These Diaphragms are marked for rectification by ABF QA Inspector and VT is not accepted. Hence MT is not carried out.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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